

Work Order ID 78038

78038

Page 1

December-28-11 8:10:52 AM

Item ID: D4034-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Upper Rib Assembly
 Start Date: 28/12/2011 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 12/01/2012 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/12/28 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D4034 | B |

100 Weld per dwg A/R S.S. rod Batch: 4115778 0.00
100
 Large Fab Memo 0.00
 Large Fab 1- Assemble ribs to hoop and weld as per dwg DT9564
 2- Weld bushing in rib and grind weld flush as per dwg

12.02.06 (3x)

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00
110
 QC Memo 0.00
 Quality Control

12.02.07 3x

120 QC5- Inspect part completeness to step on W/O 0.00
120
 QC Memo 0.00
 Quality Control

12/12/07 (3x)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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December-28-11 8:10:52 AM

Page 2

Quality Control

12.02.07 3x

12/2/79

1202-1
(3)

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Picklist Print

December-28-11 8:10:56 AM

Page 1

Work Order ID: 78038

78038

Parent Item: D4034-041

D4034-041

Parent Item Name: Aft Upper Rib Assembly

Start Date: 28/12/2011

Required Date: 12/01/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC
per dwg revA 10.03.15 verified by:EC
DWG REV.B DD VERF:EC
IPP Rev:B as
IPP Rev:C 11.01.19 AS PER

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

| | | | | | | | | | | | | | |
|------------------|--|--------------|----|--|--|-----|------|--------|---|----|----------|--|--|
| ✓ D4034-1 Rib | | Manufactured | No | | | 100 | Each | 9.0000 | 1 | 2 | | | |
| | | | | | | | | | | ** | 12-02-06 | | |

Location Loc Qty Loc Code

WA006

9

14780

9

| | | | | | | | | | | | | | |
|------------------|--|--------------|----|--|--|-----|------|--------|---|----|----------------------|--|--|
| ✓ D4034-3 Rib | | Manufactured | No | | | 100 | Each | 1.0000 | 1 | 2 | | | |
| | | | | | | | | | | ** | B79420 → 2x 12-02-06 | | |

Location

Loc Qty

Loc Code

WA006

1

| | | | | | | | | | | | | | |
|-------------------|--|--------------|----|--|--|-----|------|--------|---|----|----------------------|--|--|
| ✓ D4021-7 Hoop | | Manufactured | No | | | 100 | Each | 8.0000 | 1 | 2 | | | |
| | | | | | | | | | | ** | B79488 → 1x 12-02-06 | | |

Location

Loc Qty

Loc Code

WA005

8

74807

8

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

December-28-11 8:10:56 AM

Page 2

Work Order ID: 78038

78038

Parent Item: D4034-041

D4034-041

Parent Item Name: Aft Upper Rib Assembly

Start Date: 28/12/2011

Required Date: 12/01/2012

Start Qty: 2.00

Required Qty: 2.00

D4021-9

Manufactured No

100

Each

106.0000

4

8

**

12x 12-02-06

✓ ***D4021-9***

Bushing

Location

Loc Qty

Loc Code

WA005

106

66437

2

70333

4

72482

36

74966

64

48x
4x

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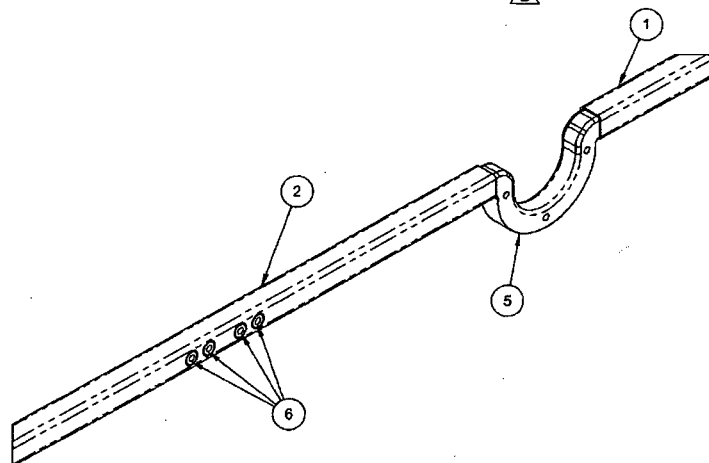
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

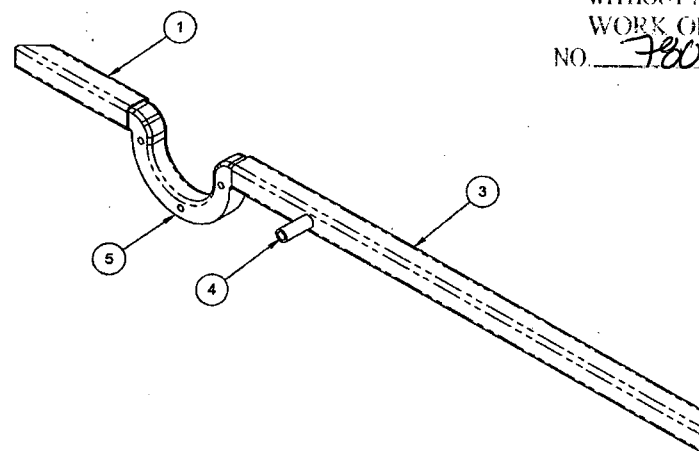
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NOTE: Date & initial all entries

| ITEM | QTY -041 | QTY -043 | P/N | DESCRIPTION |
|------|-------------|-------------|-----------|--------------------|
| | X | | D4034-041 | AFT UPPER RIB ASSY |
| | | X | D4034-043 | FWD UPPER RIB ASSY |
| 1 | 1 | 1 | D4034-1 | RIB |
| 2 | 1 | | D4034-3 | RIB |
| 3 | | 1 | D4034-5 | RIB |
| 4 | | 1 | D2327-3 | SPACER BUSHING |
| 5 | 1 | 1 | D4021-7 | HOOP |
| 6 | 4 | | D4021-9 | BUSHING |



D4034-041 AFT UPPER RIB ASSY



D4034-043 FWD UPPER RIB ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 78038 M.C.J

11/12/28

RELEASED
2011-01-18
M

| B | ADDITIONAL HOLES ADDED ON D4034-3 RIB | SC | 10.12.20 |
|------------|---------------------------------------|--|--------------|
| A | NEW ISSUE | AJS | 10.03.04 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4034 TITLE UPPER RIB ASSY, BASKET BASE COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |
| DRAWN | SC | | |
| CHECKED | IS | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 10.12.20 | REV. B | SHEET 1 OF 4 |
| | | SCALE | NTS |

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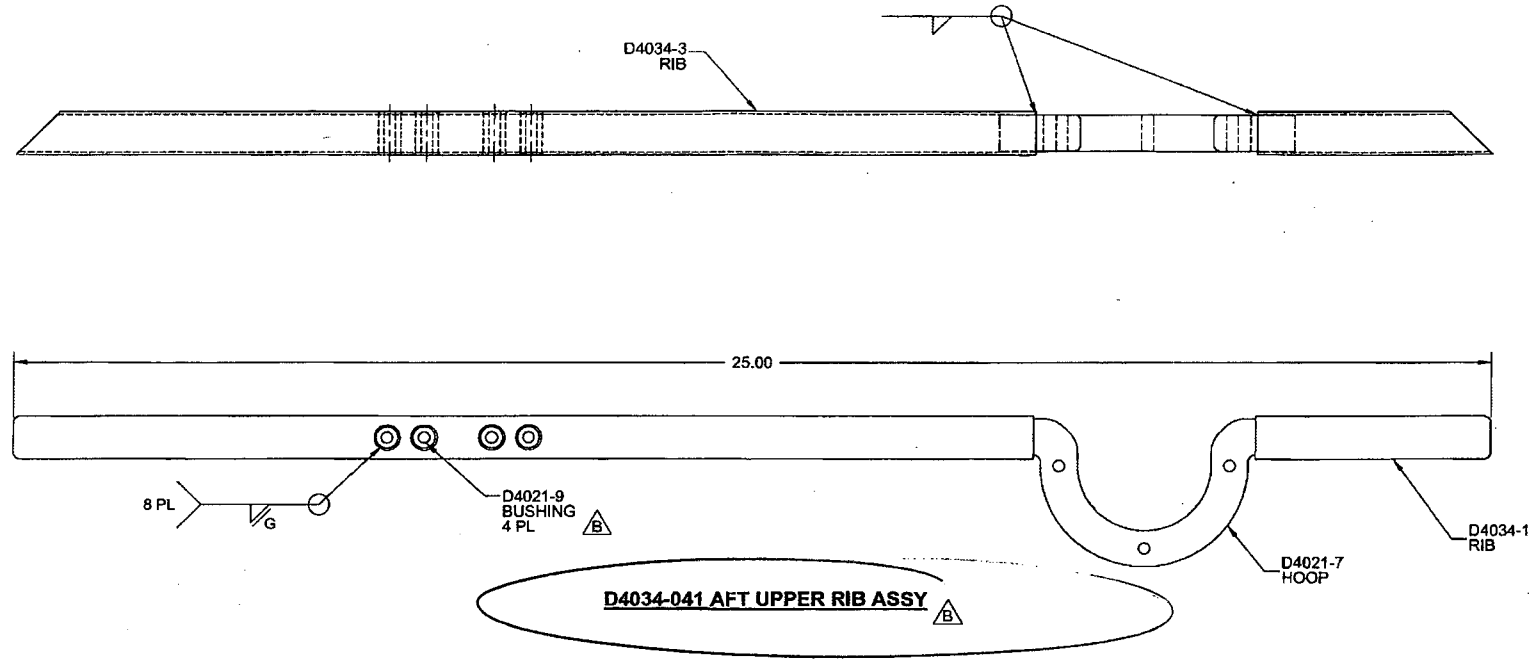
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

70038



RELEASED
2011-01-38

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.61 lbs
 - 8) WELD PER DART QSI 004

| | | | |
|------------|----------|--|--------------|
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | SC | | |
| CHECKED | JS | DRAWING NO. | REV. B |
| MFG. APPR. | JS | D4034 | SHEET 2 OF 4 |
| APPROVED | JS | TITLE | SCALE |
| DE APPR. | JS | UPPER RIB ASSY, BASKET BASE | NTS |
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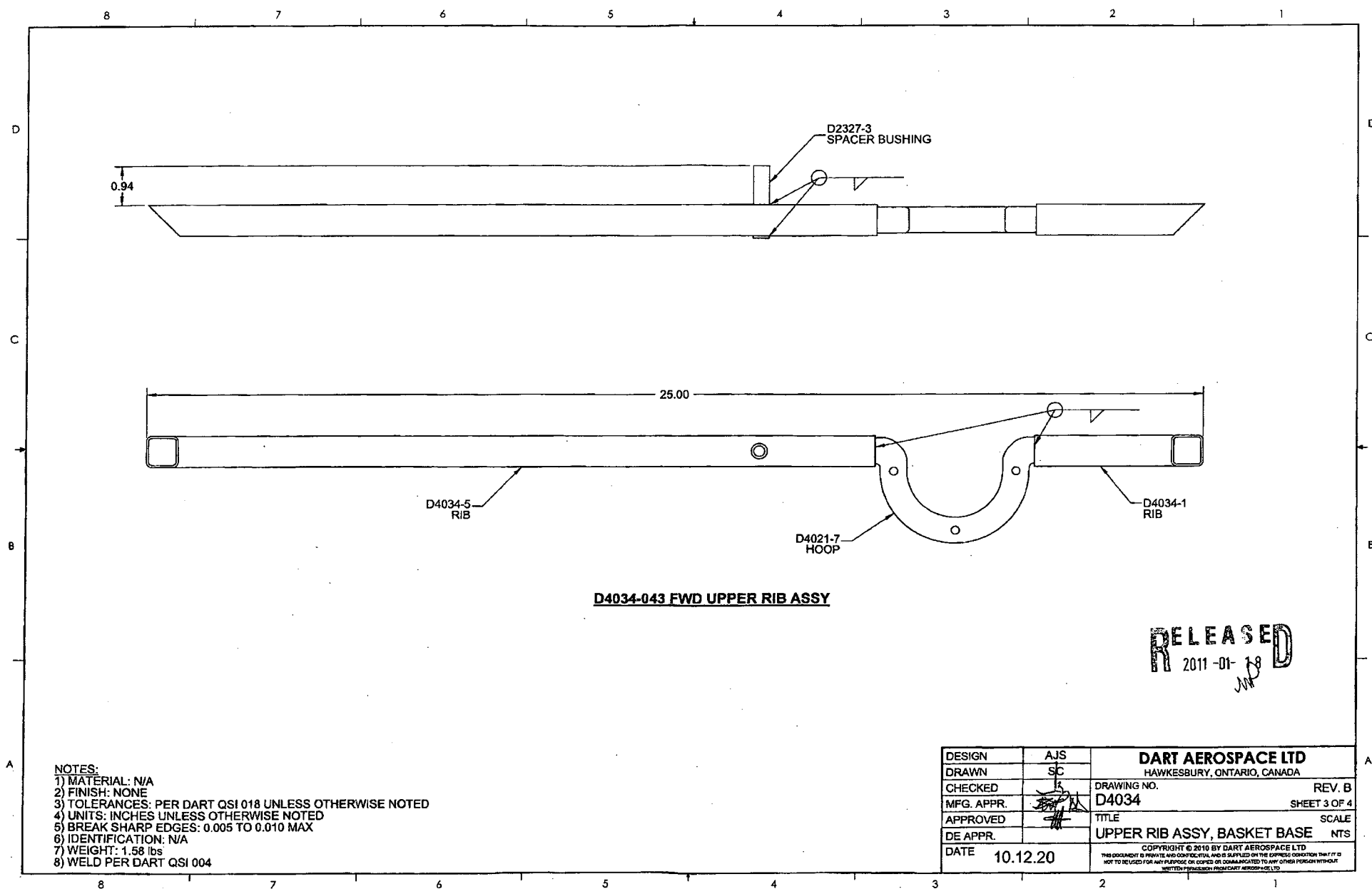
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D4034-043 FWD UPPER RIB ASSY

RELEASED
2011-01-18

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.58 lbs
- 8) WELD PER DART QSI 004

| | | | |
|------------|----------|---|--------------|
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | SC | | |
| CHECKED | SC | DRAWING NO. | REV. B |
| MFG. APPR. | | D4034 | SHEET 3 OF 4 |
| APPROVED | | TITLE | SCALE |
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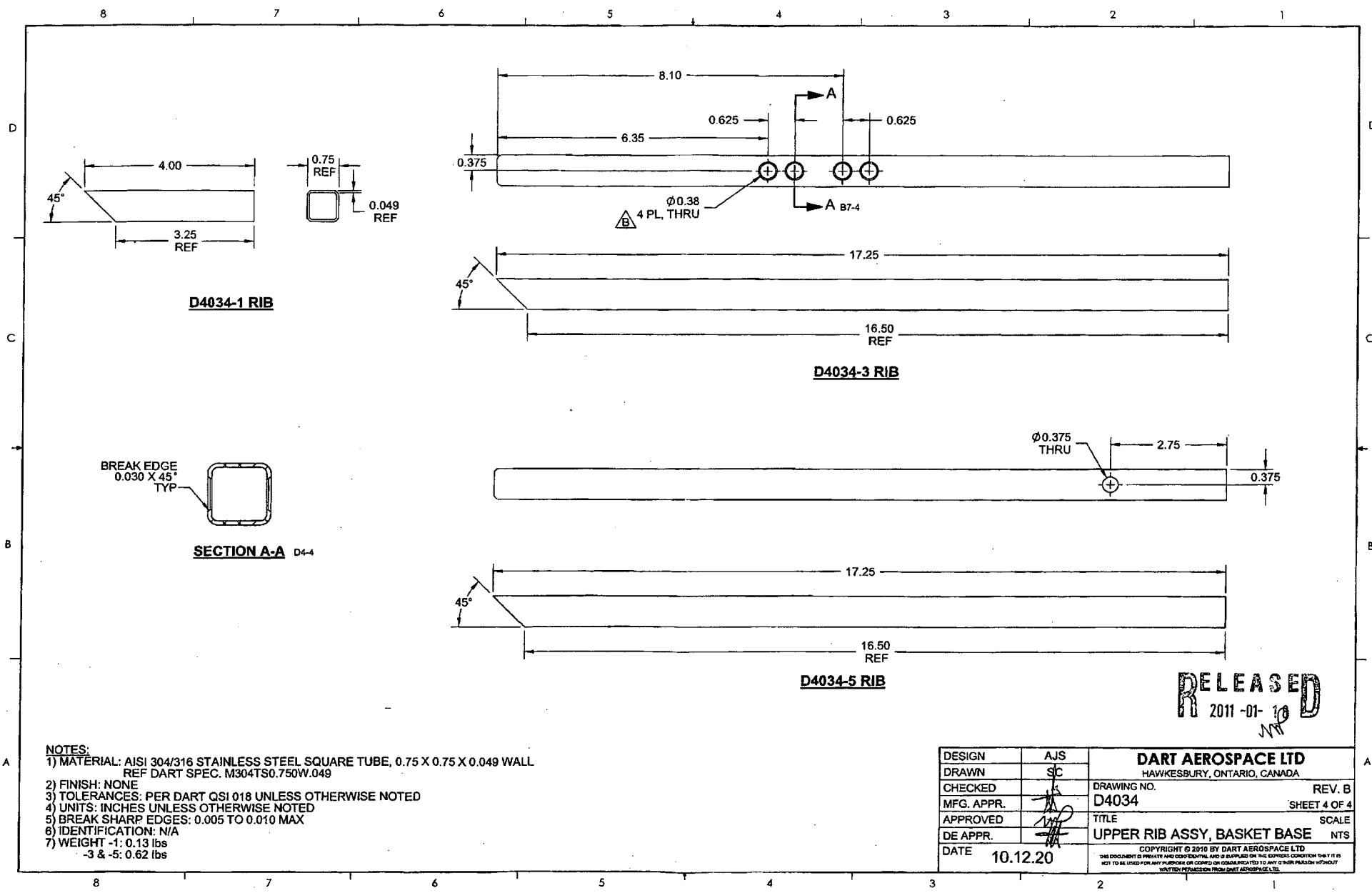
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